

Date: Wednesday, 3/12/2008 2:00:57 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 37898	
Estimate Number : 12734	
P.O. Number :	Part Number : D353525
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 36424	Material :
Written By :	Due Date : 3/24/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JB 08 03 12</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.5355 sf(s)/Unit Total : 2.1420 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 106748 JB 8-3-17

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

JB 8-3-17

(4)

2-Deburr if necessary

JB 8-3-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JB 08/03/18 (4)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326
 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

JB 08/03/18 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 2:00:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37898

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/18 (X4)

7.0

POWDER COATING

POWDER COATING



M 106442



(X4)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 08/03/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18 (X4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

08-03-18

(X4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/18

Job Completion



08/03/18

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37898
Description: Wearshoe		Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	*			
1.937	+/-0.010	1.937	*			
1.450	+/-0.010	1.450	*			
5.450	+/-0.010	5.450	*			
10.900	+/-0.010	10.900	*			
16.350	+/-0.010	16.350	*			
21.800	+/-0.010	21.800	*			
Ø0.188	+0.005/-0.001	.192	*			
12.750	+/-0.010	12.750	*			
6.75	+/-0.030	6.75	*			
6.00	+/-0.030	6.00	*			
0.300	+/-0.010	.304	*			
0.300	+/-0.010	.304	*			
0.038	+/-0.010	.034	*			

Measured by: IB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-3-17	Date: 08/03/18	Date:	N/A

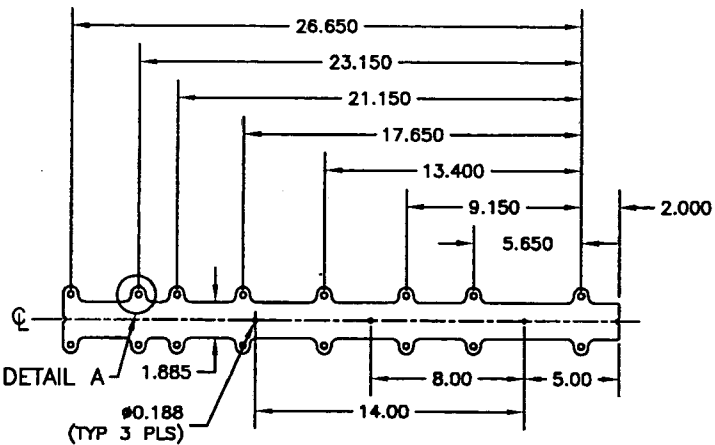
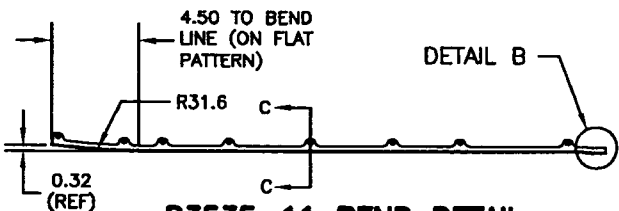
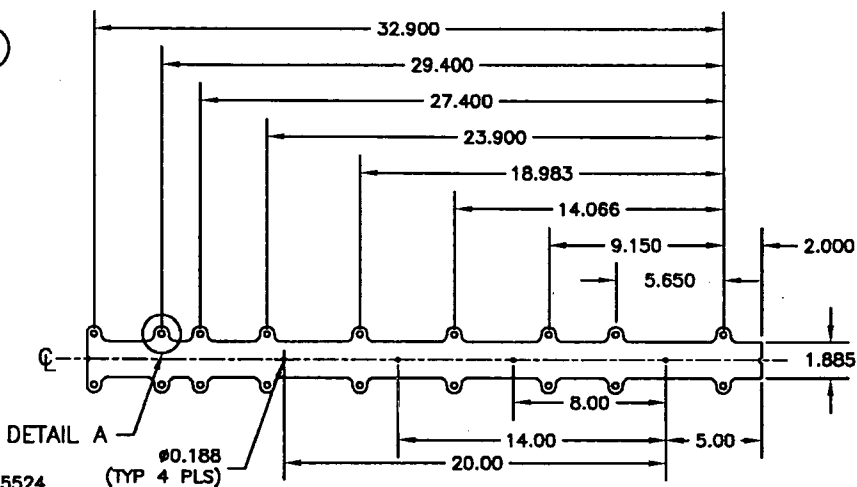
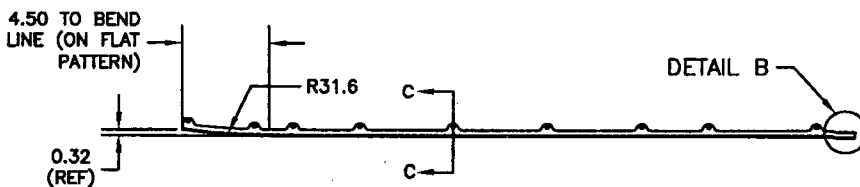
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]

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07.04.24

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
		D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

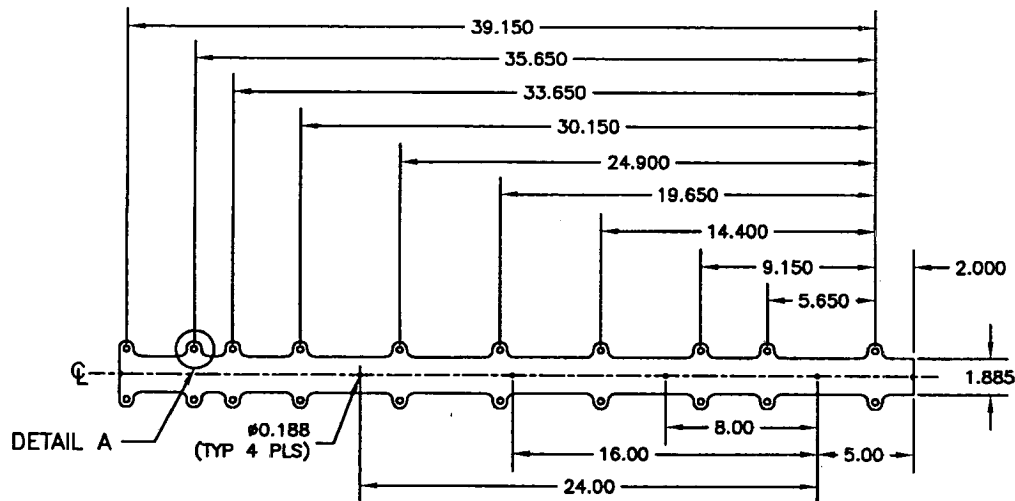
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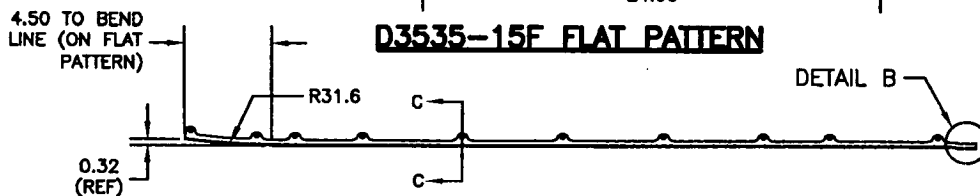
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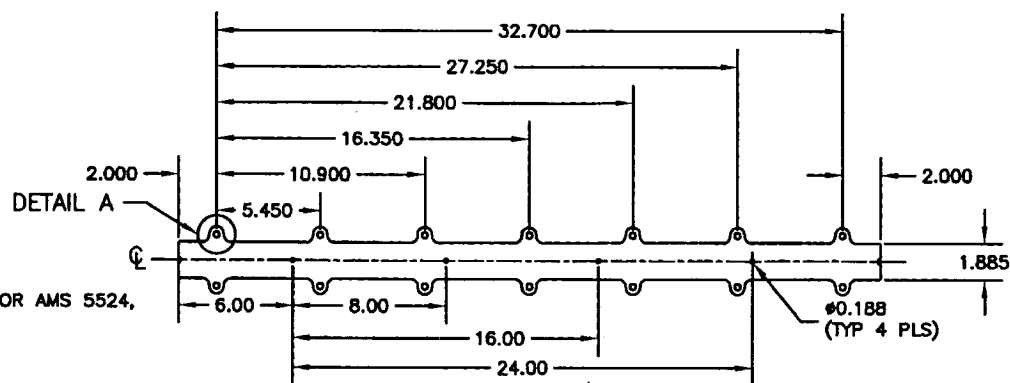
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		TITLE	WEARSHOE	SHEET 2 OF 7
				SCALE 1:10



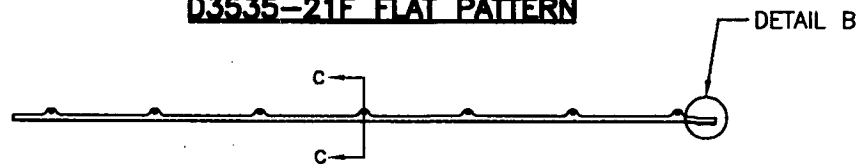
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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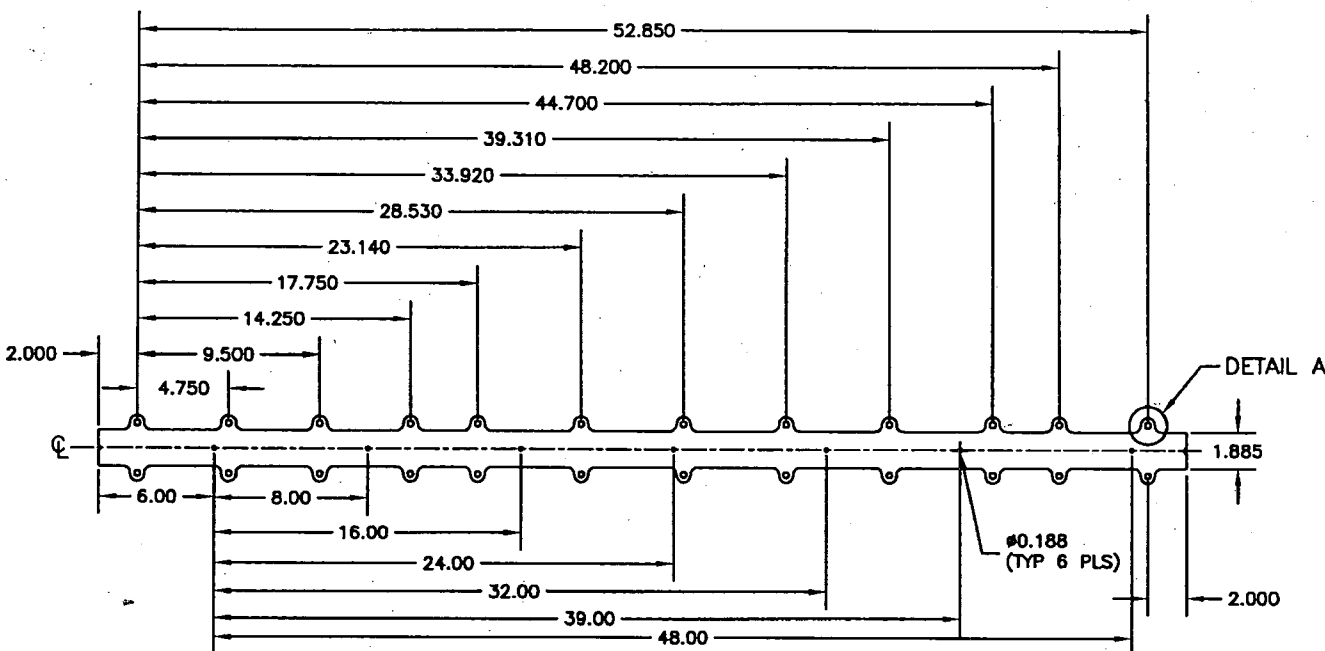
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		TITLE	WEARSHOE	SHEET 3 OF 7
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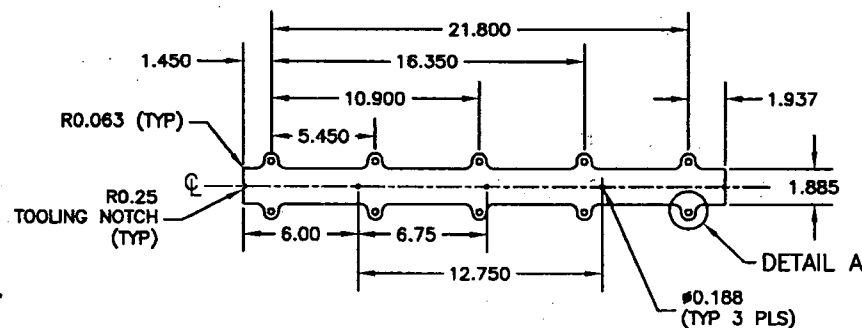


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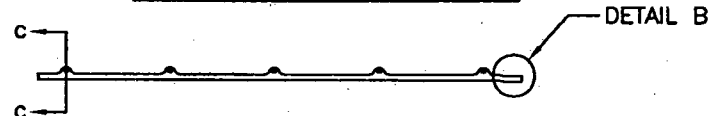


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D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

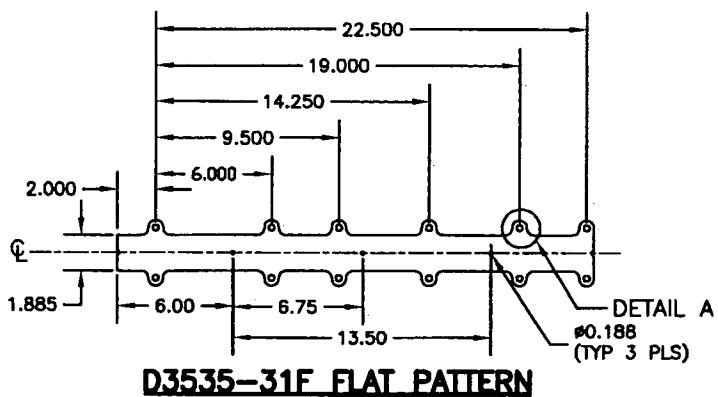
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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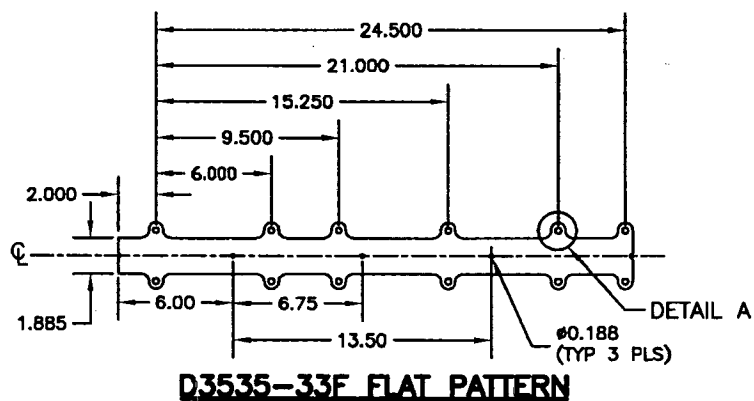
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D3535-31 BEND DETAIL



D3535-33 BEND DETAIL



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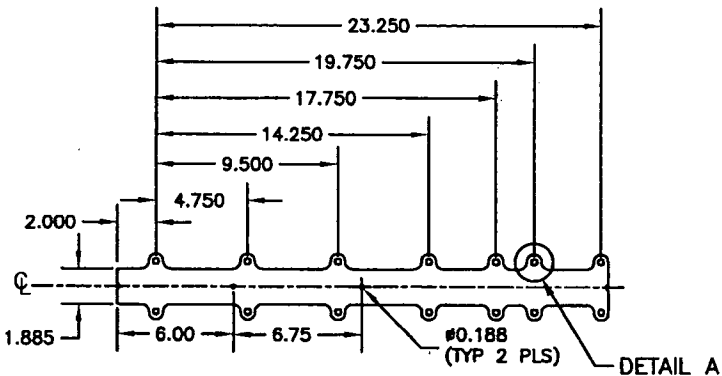
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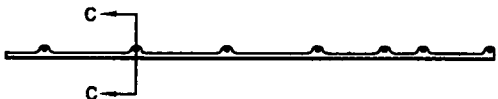
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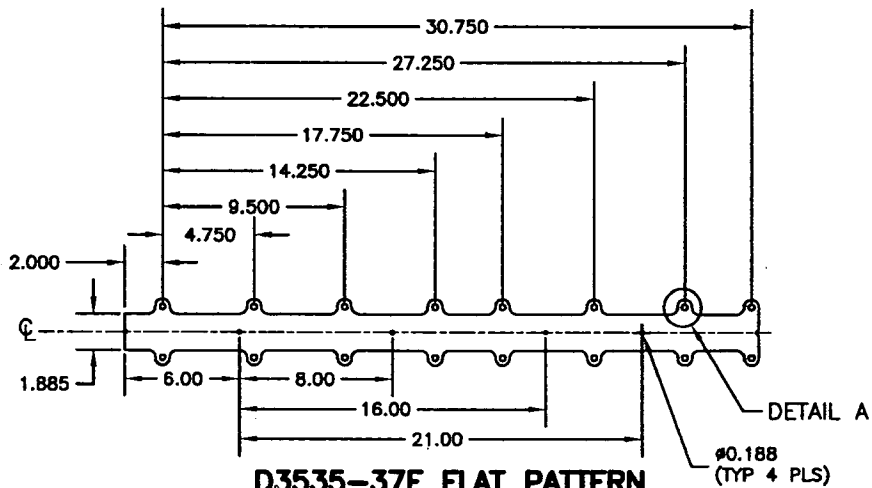
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DATE	07.04.17	DRAWING NO.	D3535	TITLE	WEARSHOE
					SHEET 5 OF 7
				SCALE	1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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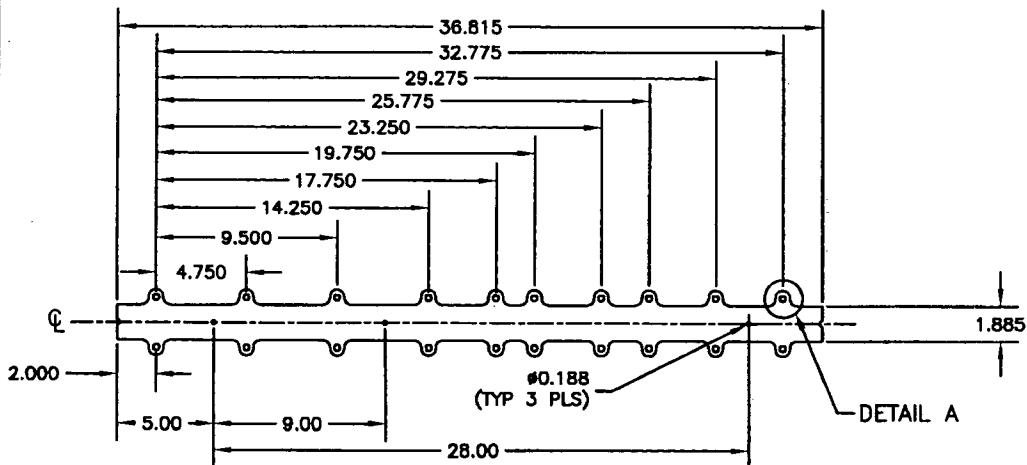
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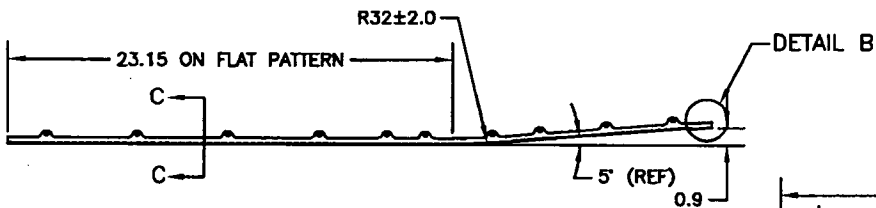
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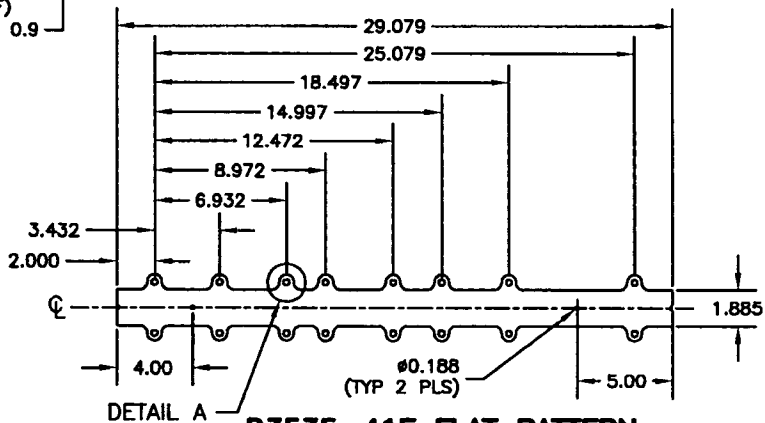
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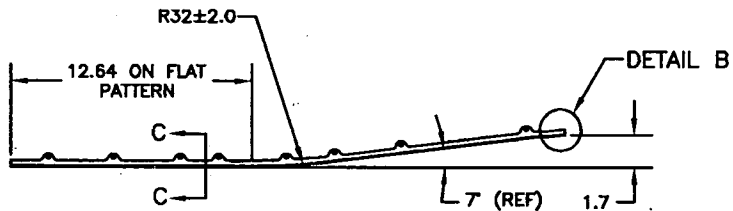
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

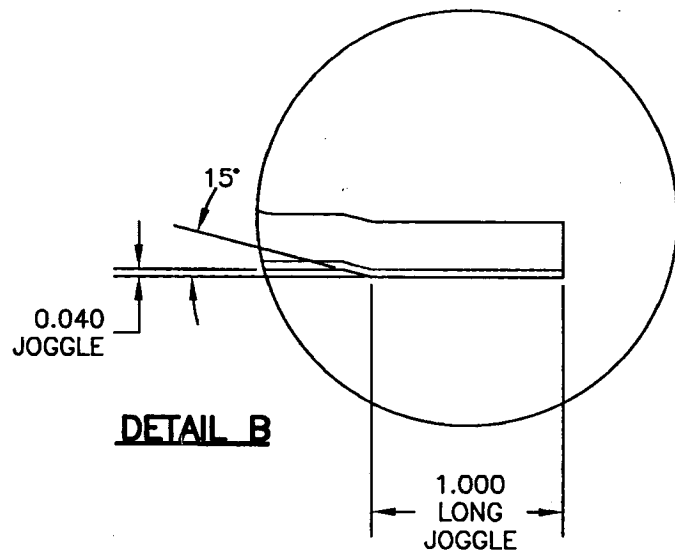
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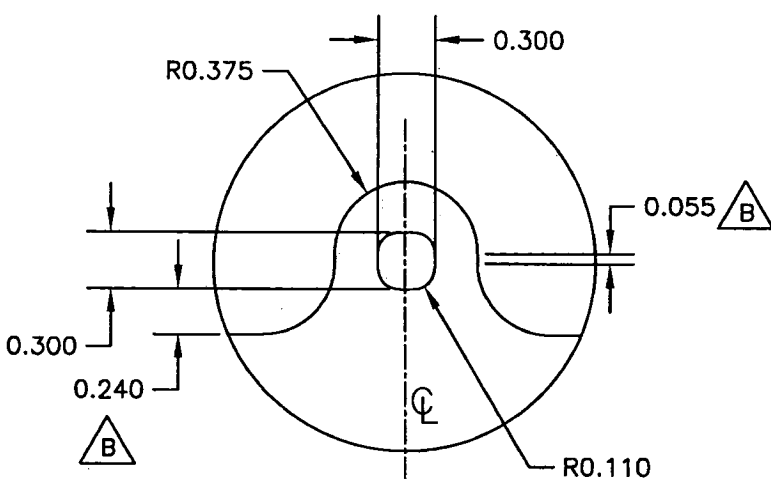


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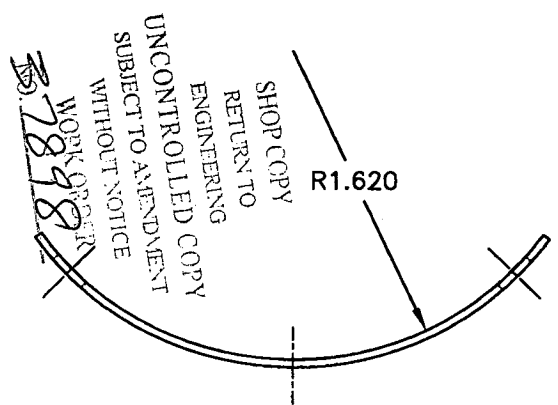
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DETAIL B



DETAIL A



SECTION C-C

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